

Work Order ID 127939

December-17-14 2:01:56 PM

127939

Page 1

Item ID: D3403-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 12/17/14 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3403	D								
100	Hardinge CNC LATHE SMALL	0.00							
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1- Turn as per Folio FA558 & Dwg D3403 Folio Rev: <u>AA</u> Dwg Rev: <u>D</u> 2-Debur								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

60

80

15-01-04

60

80

15-01-04

61

12/5-1-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St 03t</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

61
 JAN 06 2015
 DAS
 06
 9-89

15/1/6 JJ

15-1-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design									
Doc/Data									
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Picklist Print

December-17-14 2:01:55 PM

Page 1

Work Order ID: 127939

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Parent Item: D3403-3

D3403-3

Parent Item Name: Bushing

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	67.4160	0.206	13.01053			

M303R0 750

303 Round Bar 0.750

Location

Loc Qty

Loc Code

MAT028

67.416

→ m130243

23.333

m130451

36

→ m130745

8.083

4.917

8.083

RG 15-01-05

13'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

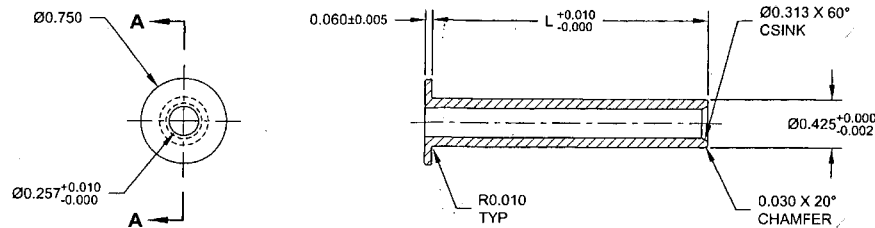
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SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07



TOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 127939 ML5
14-12-19

RELEASED
2011-10-31
ANN

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

REV.	DESCRIPTION	BY	DATE
D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5, TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF	DRAWING NO.	REV. D
CHECKED		D3403	SHEET 1 OF 1
MFG. APPR.		TITLE	SCALE
APPROVED		BUSHING	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.10.28		